

CLAIMS

What is claimed is:

- 5 1. A threading control method for performing a threading operation by moving, in synchronization with rotation of a main spindle, either a cutter or a workpiece in a feeding spindle direction, characterized in that threading start timing is altered based on at least a servo-spindle acceleration time-constant for the feeding
10 spindle.
2. A threading control method for performing a threading operation by moving, in synchronization with rotation of a main spindle, either a cutter or a workpiece in a feeding spindle direction,
15 characterized in that threading start timing is altered based on at least a servo-spindle acceleration time-constant for, and mechanical error of, the feeding spindle.
3. A threading control system for performing a threading operation
20 by moving, in synchronization with the rotation of a main spindle, either a cutter or a workpiece in a feeding spindle direction, the system comprising a means for altering threading start timing based on a servo-spindle acceleration time-constant for the feeding spindle.

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4. A threading control system for performing a threading operation by moving, in synchronization with the rotation of a main spindle, either a cutter or a workpiece in a feeding spindle direction, the system comprising a means for altering threading start timing
5 based on a servo-spindle acceleration time-constant for, and mechanical error of, the feeding spindle.